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RBT18717-15
Job Sheet 195376



Part No: RBT18717-15

Job Qty: 4 pcs

Part Name: Ratchet Head



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Due Date: 6/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18717 Rev 1B IPP Rev. A 19.05.10 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S192568



Part: RBT18717-15

Job No: 195376

Serial No/Batch: S192568

Revision: 1B

Inspector:

Exp Date:

Instructions:

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Date: 06/21/19

lajeunesse.marie

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Handfinish - 7 - BeadBlast	4 pcs	6/7/19		0.00	1.00	Handfinish - 7 - 1		BEB 19-06-21
							Handfinish - 7 - 2		
100	Small Fab - 2 - B4B	4 pcs	6/7/19		0.00	0.27	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	4 pcs	6/7/19		0.00	0.00	QC 5 - 10		DAS 40 9-89 JUN 25 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	4 pcs	6/7/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	4 pcs	6/7/19		0.00	0.00	QC 21 - SA - 21		DAS 70 9-89 JUN 27 2019
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op 90 - 1-Measure out 1.250". 2-Mask off 0.750" of forward end of wrench. ***Do not remove chrome from forward end of Descriptions: wrench*** 3-Remove 0.5" of chrome on aft end of wrench. Only remove at area to be welded, not on piece that will be discarded.

100 - 1-Cut wrench as per drawing. 2-Deburr

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
05045174	Mini Tatchet, 3-3/4"	4 Ea (1 ea)	90-Handfinish - 7 - BeadBlast	M.M. 010525 5184029

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Handfinish - 7 - BeadBlast	05045174	4	1	0

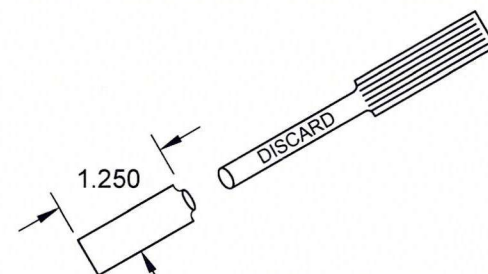
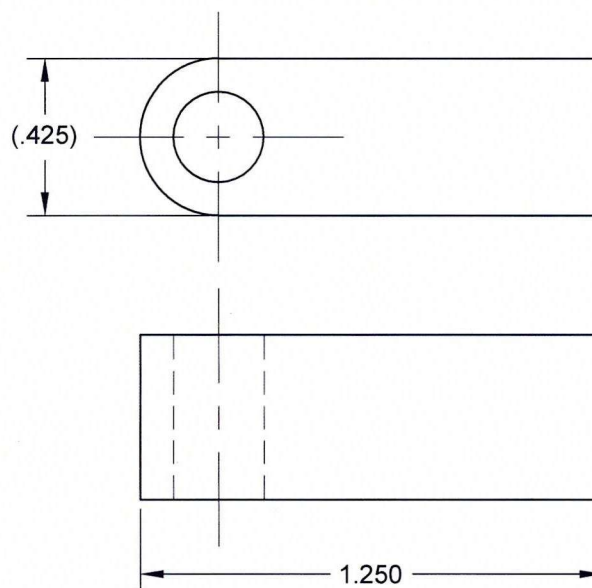
Part Specifications

Specifications could not be found.

Plex 5/21/19 10:41 AM Dart.lajeunesse.marie

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1B	-15 ADDED DIM (.425).	7/3/14	DPD



CUT OFF RATCHET HANDLE
AS SHOWN, FLIP RATCHET
HEAD TO THE R/H ROTATION
POSITION FOR WELDING.

NOTE:
REMOVE MANUFACTURE INFO, LEAVE TORQUE INFO.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195376 MWS
190521

(-15)
RATCHET
HEAD

DART AEROSPACE	
TITLE WRENCH SET, COMPRESSOR CASE	
DWG NO. RBT18717-15	REV 1B
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .010 FRACTIONS ± 1/32 XX ± .03 ANGLES ± 5° X ± .1	APPROVED: <i>D Weil</i> HEAT TREAT FINISH
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC USED ON MODEL R.R. 250
SCALE 2:1	DATE 8-26-09 SHEET 7 of 11

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					